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(54) **DIAMOND AND DIAMOND COMPOSITE MATERIAL**

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(51) **Int. Cl.**
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H01L 21/04 (2006.01)
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(52) **U.S. Cl.**

CPC **H01L 29/1602** (2013.01); **C23C 14/0641** (2013.01); **C23C 16/27** (2013.01); **C23C 16/34** (2013.01); **C23C 24/04** (2013.01); **C23C 28/046** (2013.01); **H01L 21/0242** (2013.01); **H01L 21/02439** (2013.01); **H01L 21/02444** (2013.01); **H01L 21/02474** (2013.01); **H01L 21/02507** (2013.01); **H01L 21/02521** (2013.01); **H01L 21/02527** (2013.01); **H01L 21/02601** (2013.01); **H01L 21/02628** (2013.01); **H01L 21/0405** (2013.01)

(58) **Field of Classification Search**

USPC 257/77; 428/408, 698; 427/577
See application file for complete search history.

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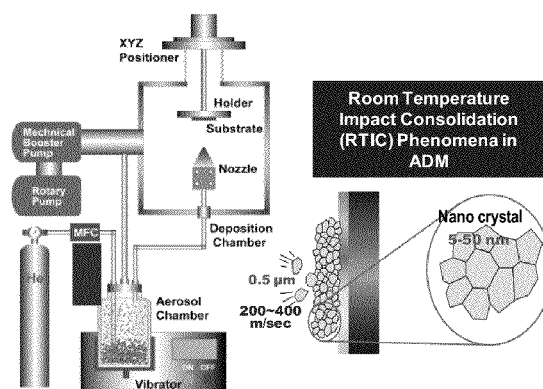
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(57) **ABSTRACT**

A structure having: a substrate and a diamond layer on the substrate having diamond nanoparticles. The diamond nanoparticles are formed by colliding diamond particles with the substrate. A method of: directing an aerosol of submicron diamond particles toward a substrate, and forming on the substrate a diamond layer of diamond nanoparticles formed by the diamond particles colliding with the substrate.

34 Claims, 8 Drawing Sheets



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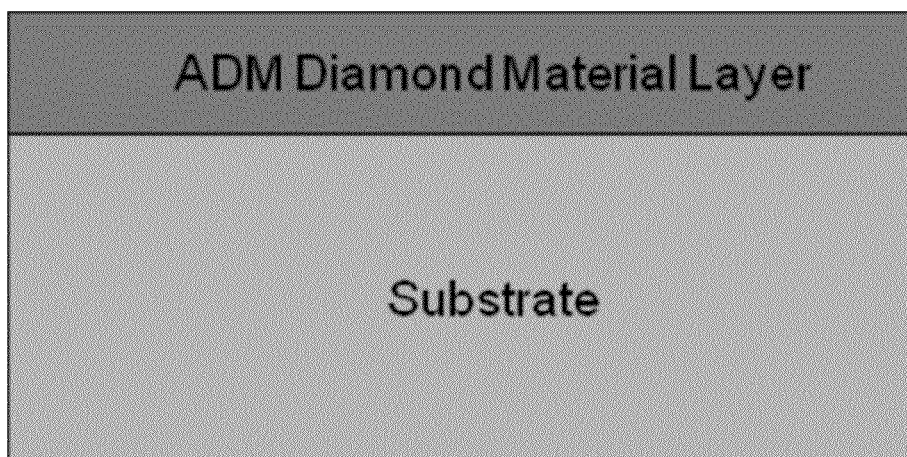
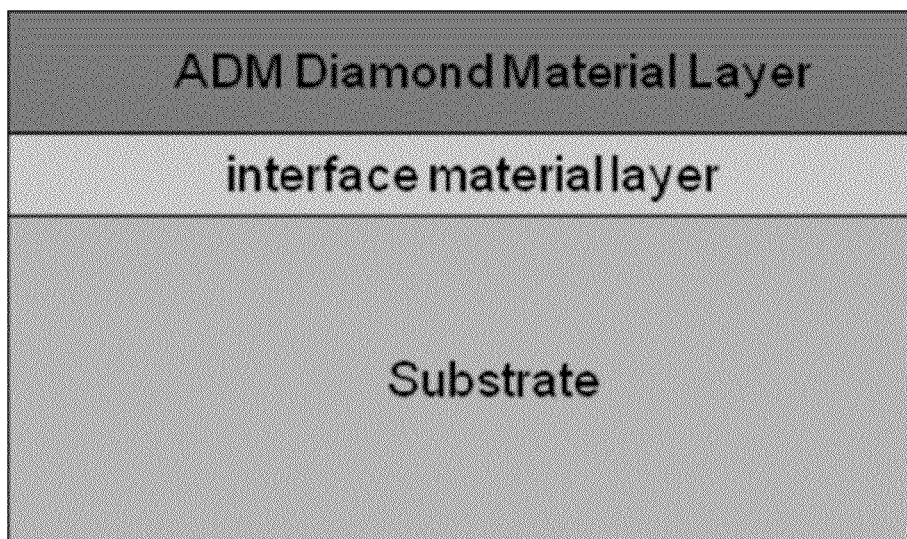
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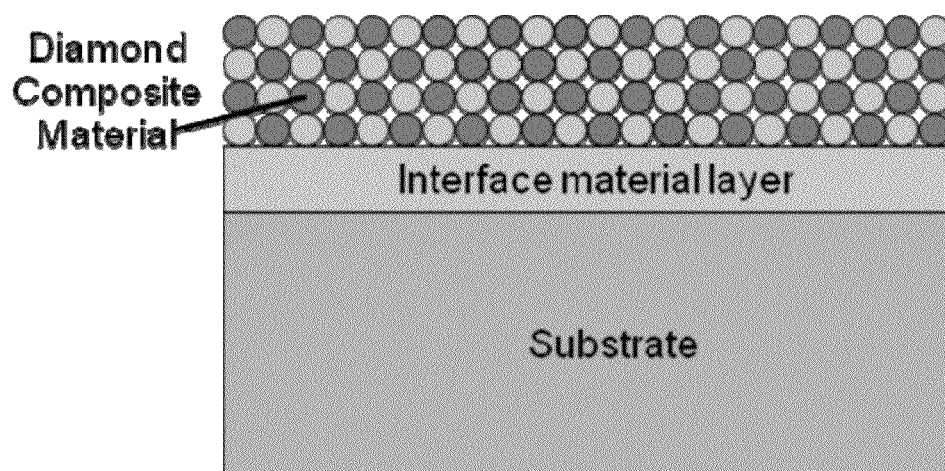
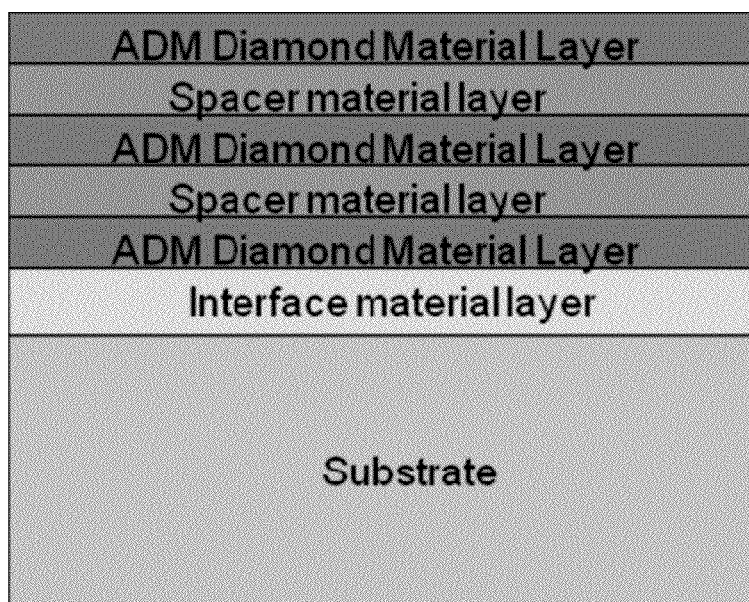
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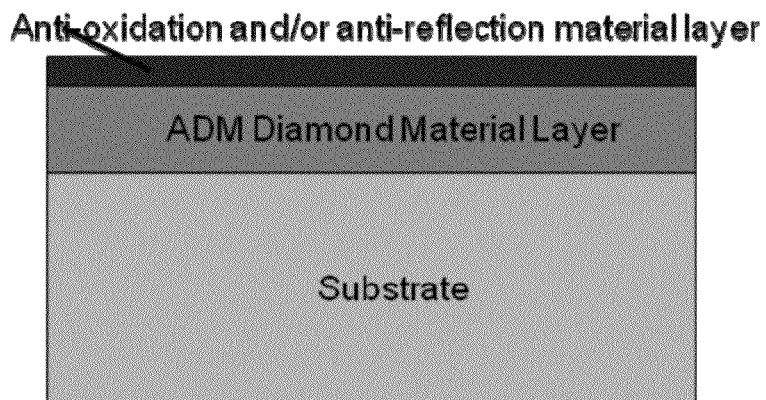
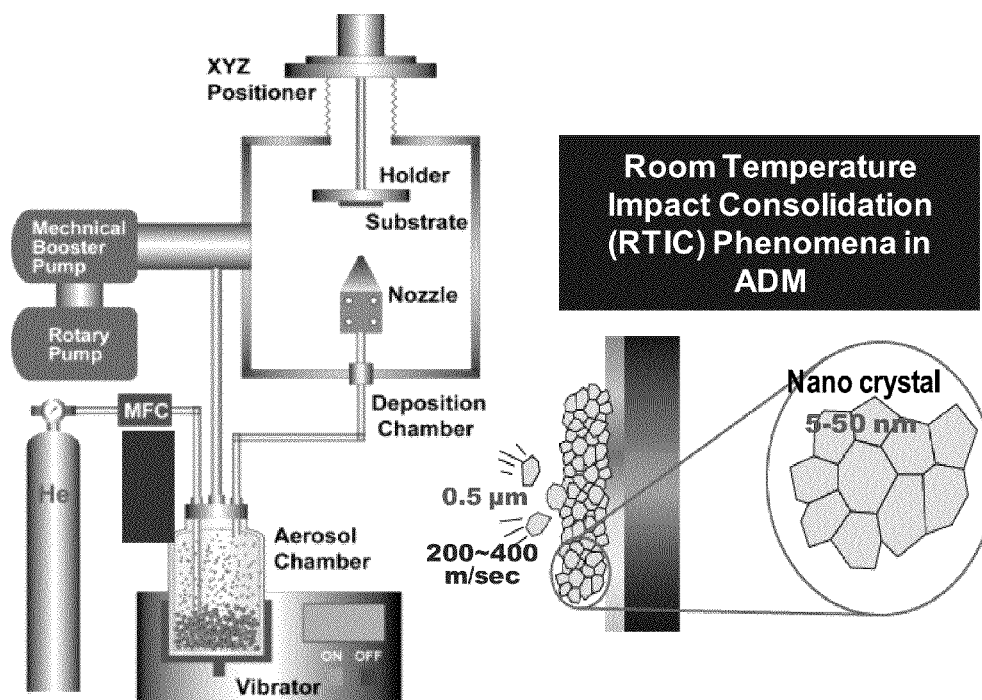
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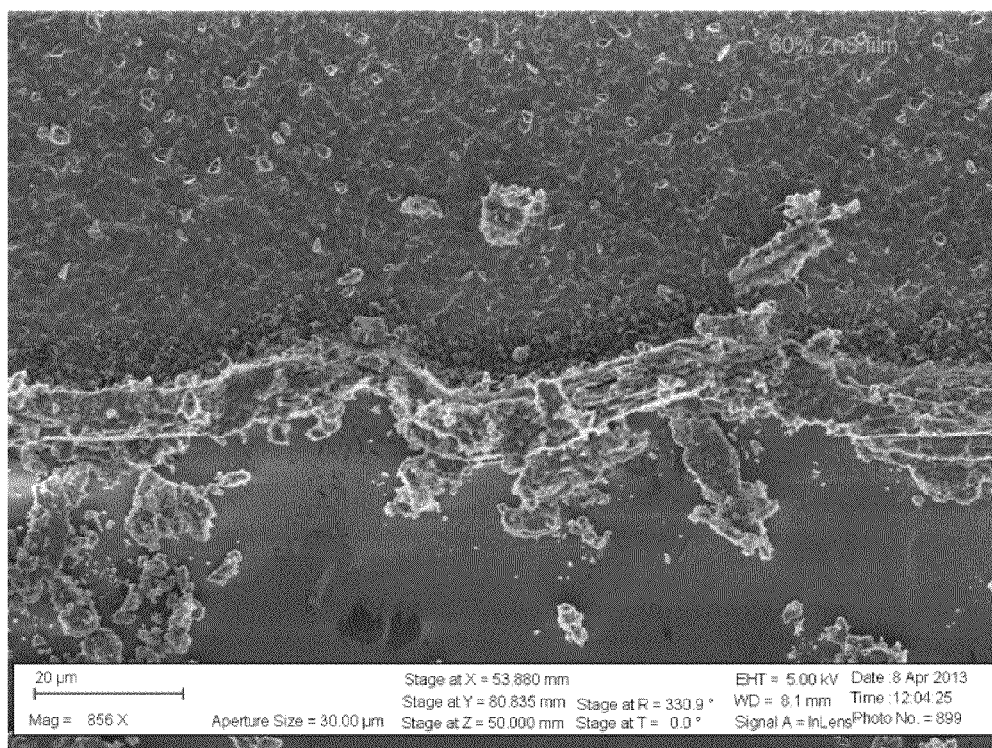
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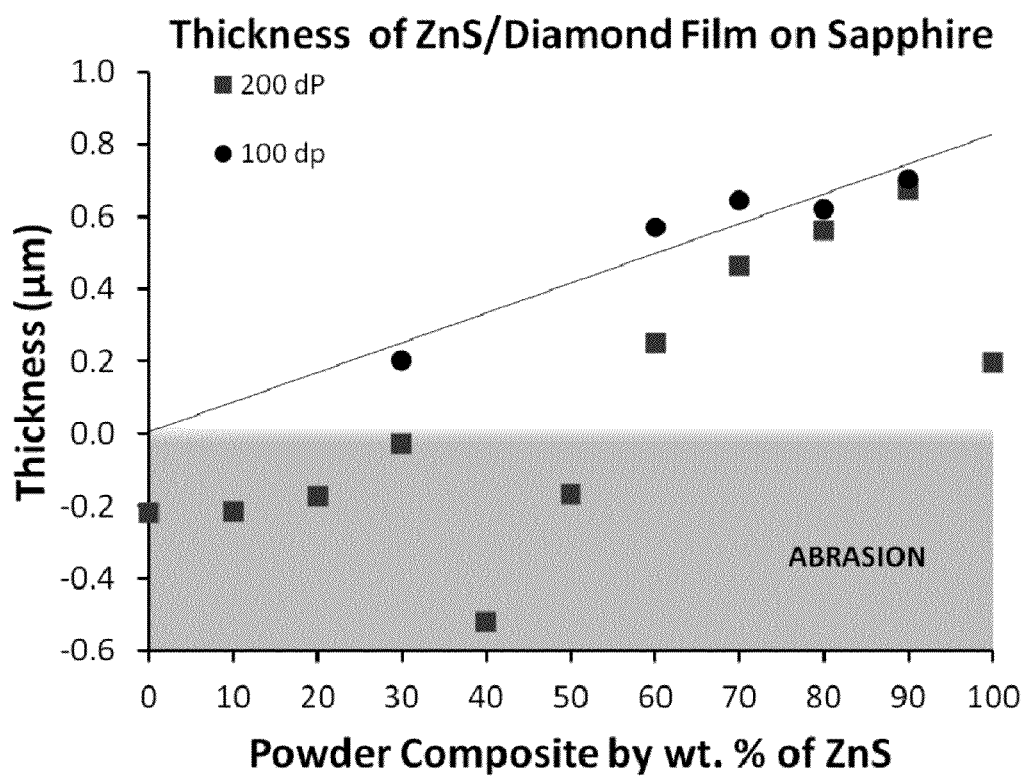
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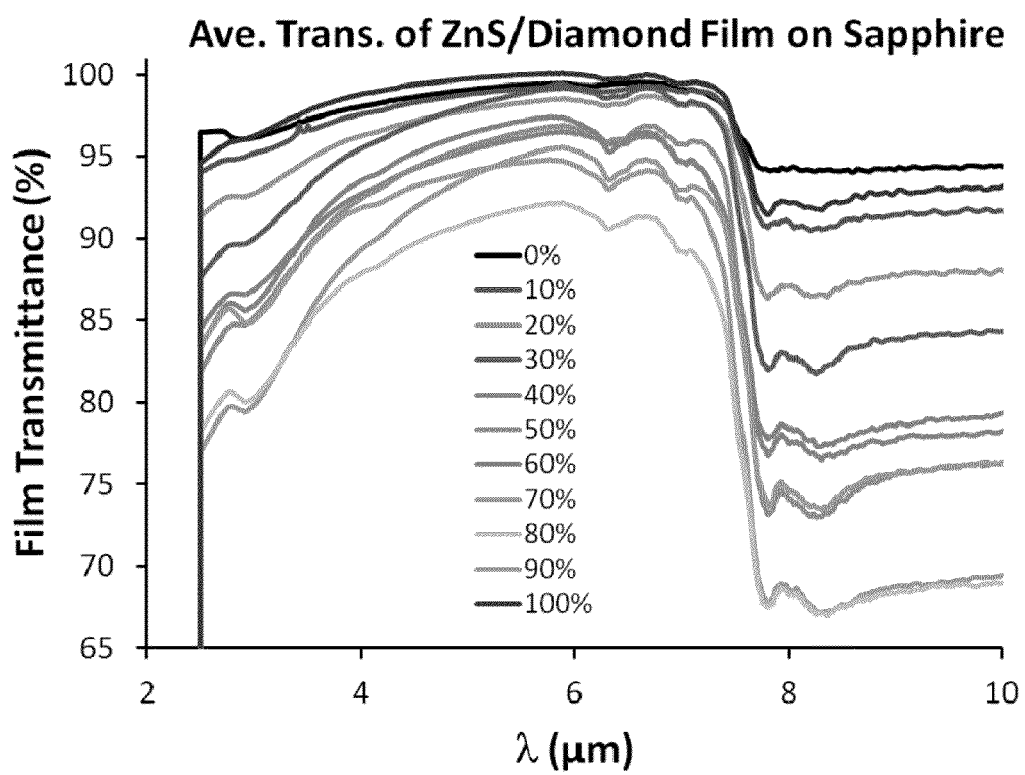
*Fig. 1**Fig. 2*

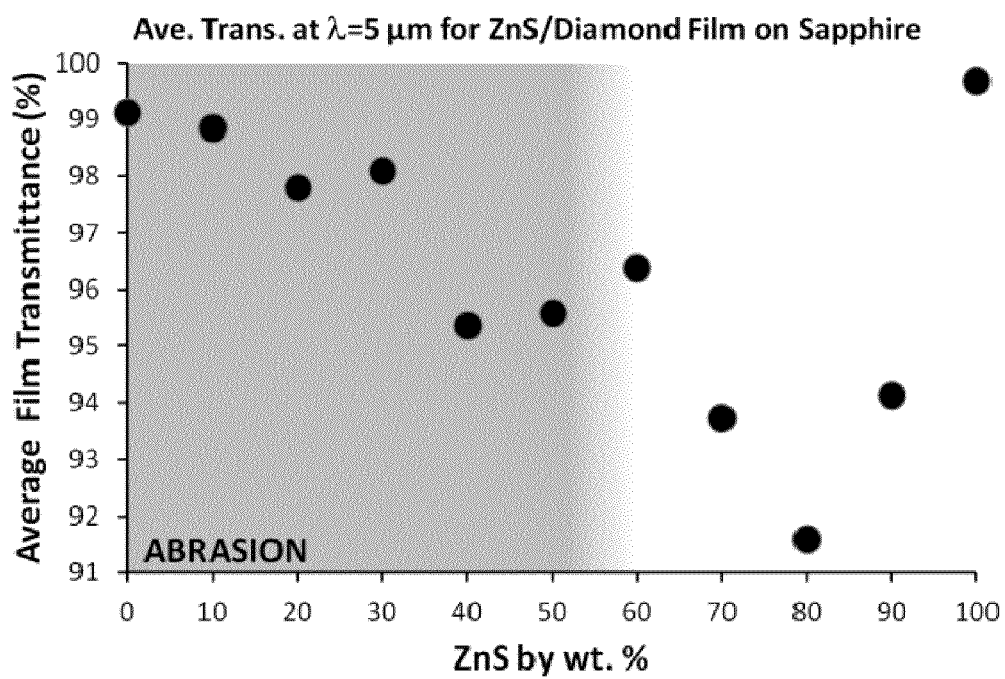
*Fig. 3**Fig. 4*

*Fig. 5**Fig. 6*

**Fig. 7**

*Fig. 8*

**Fig. 9**

*Fig. 10*

Deposition and Densification Mechanism of ADM

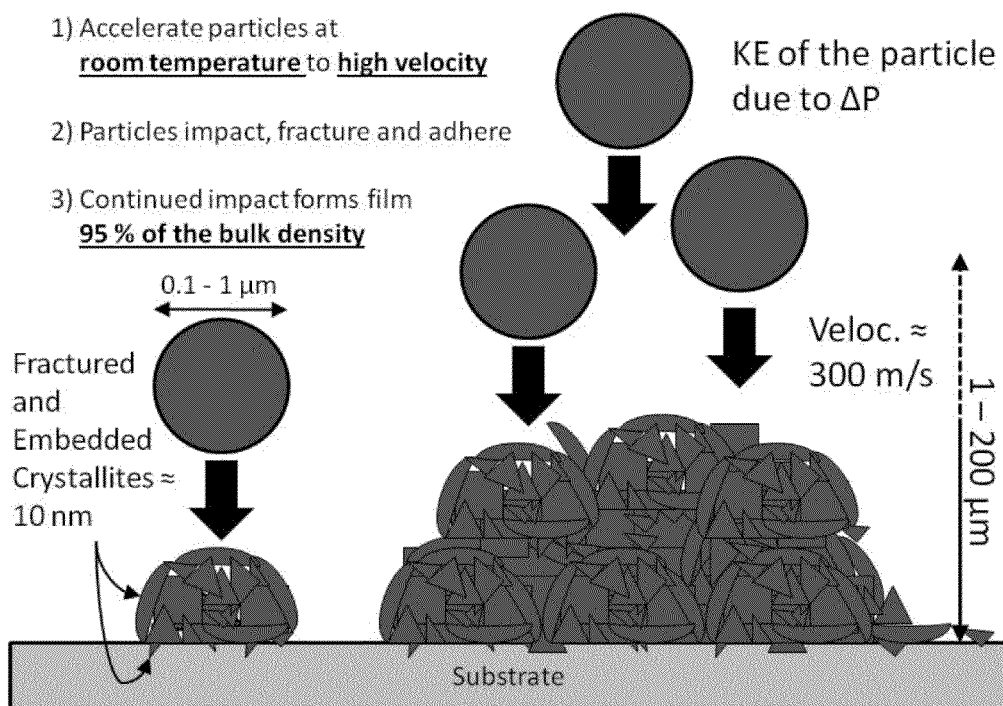


Fig. 11

DIAMOND AND DIAMOND COMPOSITE MATERIAL

This application claims the benefit of U.S. Provisional Application No. 61/649,693, filed on May 21, 2012 and U.S. Provisional Application No. 61/817,848, filed on Apr. 30, 2013. The provisional applications and all other publications and patent documents referred to throughout this nonprovisional application are incorporated herein by reference.

TECHNICAL FIELD

The present disclosure is generally related to diamond films.

DESCRIPTION OF RELATED ART

The aerosol deposition method (ADM) is a film fabrication technique (Akedo et al., "Microstructure and Electrical Properties of Lead Zirconate Titanate ($\text{Pb}(\text{Zr}_{52}/\text{Ti}_{48})\text{O}_3$) Thick Films Deposited by Aerosol Deposition Method" Jpn. J. Appl. Phys. 38, Part 1, No. 9B, (1999) 5397-5401; Akedo et al., "Piezoelectric properties and poling effect of $\text{Pb}(\text{Zr}, \text{Ti})\text{O}_3$ thick films prepared for microactuators by aerosol deposition" Appl. Phys. Lett. 77 (2000) 1710-1712) that utilizes an impact solidification phenomenon of ultra fine particles. In this method crystalline particles of submicron diameters are accelerated through a nozzle and fractured to a size of approximately 10-50 nm upon impact with the substrate. These ultra fine crystalline particles are thus bonded together by mechanochemical reactions. With the ADM, a film is formed by restructuring the ultra fine crystalline particles so that the crystalline structure of the raw powder is maintained in the process of the film fabrication. This enables fabrication of film that has the same crystalline structure as the raw powder. Aerosol deposition films are typically formed at room temperature, but additional annealing can be performed to improve the properties of the deposited films.

BRIEF SUMMARY

Disclosed herein is a structure comprising: a substrate and a diamond layer on the substrate comprising diamond nanoparticles. The diamond nanoparticles are formed by colliding diamond particles with the substrate.

Also disclosed herein is a method comprising: directing an aerosol comprising submicron diamond particles toward a substrate; and forming on the substrate a diamond layer comprising diamond nanoparticles formed by the diamond particles colliding with the substrate.

BRIEF DESCRIPTION OF THE DRAWINGS

A more complete appreciation of the invention will be readily obtained by reference to the following Description of the Example Embodiments and the accompanying drawings.

FIG. 1 shows an ADM diamond material layer on a substrate.

FIG. 2 shows an ADM diamond material layer on interface material layer on a substrate

FIG. 3 shows an ADM diamond composite material layer on an interface material layer on a substrate.

FIG. 4 shows an ADM stacked diamond/spacer material layer on an interface material layer on a substrate

FIG. 5 shows an anti-oxidation and/or anti-reflection material layer on an ADM diamond material layer on a substrate.

FIG. 6 schematically illustrates the ADM apparatus.

FIG. 7 shows an SEM image of the surface of 60% Z/D film at the film edge. Thickness is 0.2 μm . The bottom of the image is exposed sapphire. The top is the Z/D composite film. Scale is 20 μm .

FIG. 8 shows a profile of a Z/D composite coating on sapphire. Legend is differential pressure (dP). As the wt. % of ZnS increases the film profile transitions from abrasion (grey region) to formation. Lowering the kinetic energy reduces the abrasion. The line fit is to the 100 dP data.

FIG. 9 shows the average transmittance of Z/D films shown by wt. % of ZnS. The cut-off wavelength for the sapphire substrate occurs around 7 μm indicated by the sharp drop. The rounding below 6 μm is due to an absorption band in diamond.

FIG. 10 shows the transmittance of Z/D film at $\lambda=5 \mu\text{m}$ vs. wt. % of ZnS. These data represent the trend within a diamond absorption band. The shaded region corresponds to abrasion.

FIG. 11 shows a proposed mechanism of ADM process. Submicron particles are accelerated to hundreds of m/s whereupon they impact with a substrate, fracture, and embed forming the anchor layer. Subsequent impacts build up the film and increases film density.

DETAILED DESCRIPTION OF EXAMPLE EMBODIMENTS

In the following description, for purposes of explanation and not limitation, specific details are set forth in order to provide a thorough understanding of the present disclosure. However, it will be apparent to one skilled in the art that the present subject matter may be practiced in other embodiments that depart from these specific details. In other instances, detailed descriptions of well-known methods and devices are omitted so as to not obscure the present disclosure with unnecessary detail.

ZnS and ZnSe are desirable materials for infrared windows but need a coating material deposited on the surface to protect the ZnS and ZnSe window material from rain damage or sand damage. Diamond is an attractive coating material on ZnS and ZnSe because diamond has good transmission in the infrared bands. A diamond coating on the ZnSe or ZnSe windows is desirable because the diamond coating may be resistant to rain impact or sand impact. Germanium is also an attractive material because it has good transmission in the infrared bands.

Disclosed herein is a method to make a diamond or a diamond composite material on a substrate material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window) using the aerosol deposition method. Also disclosed is a structure and method to make a diamond and a diamond composite material on an infrared window or infrared dome, with an optional interface material between the diamond or diamond composite material and the infrared window or infrared dome material. The diamond nanoceramic or polyceramic coating deposited on a material surface by aerosol deposition can provide a high temperature, high thermal conductivity coating on a material. ADM can deposit a material layer on a non-planar or curved substrate. This is an important requirement for deposition of coating material on a dome surface.

The diamond composite material may comprise, for example, a composite of diamond and germanium (Ge), diamond and zinc selenide (ZnSe), or diamond and zinc sulfide (ZnS). The composite may comprise nanocrystals or polycrystals of diamond with germanium nanocrystals or polycrystals, ZnSe nanocrystals or polycrystals, ZnS nanocrystals or polycrystals, or combinations of two or more of diamond, ZnSe, ZnS nanocrystals or polycrystals.

One potential advantage of the composite materials is that they may be transparent in both the mid-infrared and long-wavelengths. The composites can be used as coatings on ZnS or ZnSe domes or windows to provide mechanical protection. Another potential advantage of the composite materials is that the composite material can have a closer thermal expansion match to ZnS or ZnSe window or dome material than a diamond material coating alone. The composite coating on ZnS or ZnSe may have a closer thermal expansion coefficient than the diamond on ZnS or diamond on ZnSe material structure and thus may allow a wider temperature excursion without the composite coating material delaminating (or cracking within the composite material) from the ZnS or ZnSe dome or window. (Diamond thermal expansion coefficient is approximately $1 \times 10^{-6} \text{ } ^\circ\text{C}^{-1}$, germanium thermal expansion coefficient is approximately $5.8 \times 10^{-6} \text{ } ^\circ\text{C}^{-1}$, ZnS thermal expansion coefficient is approximately $6.3 \times 10^{-6} \text{ } ^\circ\text{C}^{-1}$, and ZnSe thermal expansion coefficient is approximately $7.1 \times 10^{-6} \text{ } ^\circ\text{C}^{-1}$).

The ADM approach can deposit a coating material at low temperatures (such as at room temperature) on a material. Methods for low temperature deposition of coating material on ZnS or ZnSe are desirable because ZnS and ZnSe will degrade if a high temperature is used to deposit the coating material. For the case of diamond material layer for application to protection of infrared windows, the substrate will typically be ZnS or ZnSe substrate (window) materials.

Several variations in the method of making the structure may be used separately or in any combination. In the main method, an aerosol comprising submicron diamond particles is directed toward a substrate. A diamond layer comprising diamond nanoparticles is formed on the substrate, and is formed by the diamond particles colliding with the substrate as shown in FIG. 1. Optionally, an interface layer is deposited on the substrate before forming the diamond layer as shown in FIG. 2. The diamond layer may be a diamond composite layer when the aerosol comprises a second powder, as shown in FIG. 3 (also with an interface layer). The structure may also include a spacer layer on the diamond layer, optionally one or more sets of alternating diamond and spacer layers, and a final diamond layer as shown in FIG. 4 (also with an interface layer). An anti-oxidation or anti-reflective layer may also be deposited on the diamond layer as shown in FIG. 5 (also with an interface layer). The structure may also include an optional sealing layer and/or an optional nucleation layer. Also, diamond turning can be used to reduce the surface roughness on top surface of the diamond material, diamond composite material, CVD nanocrystalline diamond layer, or CVD diamond layer.

Example structures include, but are not limited to:

ADM is used to deposit a diamond material layer directly on a material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window).

ADM is used to deposit a diamond material layer an interface material layer on a material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window).

ADM is used to deposit a diamond composite material layer an interface material layer on a material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window).

ADM is used to deposit a stacked diamond/spacer material layer on a material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window).

ADM is used to deposit a stacked diamond/spacer material layer on an interface material layer a material (structural material, mechanical material, substrate, infrared dome, or infrared window).

ADM is used to deposit a graded diamond composite material layer on a material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window).

ADM is used to deposit a graded diamond composite material layer on an interface material layer on a material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window).

For the case of diamond material layer or diamond composite material layer for application to protection of infrared windows, the substrate can be ZnS and ZnSe substrate (window) materials but the substrate can be other materials known to those skilled in the art such as spinel window material. The substrate can be, but not limited to microcrystalline, polycrystalline, ceramic, single-crystal, or non-crystalline, or the like. One form of ZnS material is formed from hydrogen sulfide gas and zinc vapor. One form of a substrate is deposited CVD zinc sulfide that is modified by a post-deposition hot isostatic pressing. The substrate can be planar or non-planar.

The substrate may be patterned with etched surfaces to provide increased adhesion of the optional interface material layer, the diamond material layer, or the composite diamond material layer to the substrate. The substrate with the patterned and etched surface structure can have topography on the substrate surface that can provide improved adhesion of material layers to the surface of the substrate.

The diamond material layer that is deposited by ADM is typically a nanocrystalline diamond material layer. The typical operation for the ADM method is that approximately 0.5 micron size particles are directed with a velocity of approximately 250 m/s toward a substrate. The particles impact with the substrate and fracture into nanocrystals with a size of approximately 10-50 nm. These ultra fine diamond crystalline particles are thus bonded together by mechanochemical reactions. Aerosol deposition films may be formed at room temperature, but additional annealing can be performed to improve the properties of the deposited films. It may be desirable that the ambient used for the anneal has a low percentage of oxygen or is oxygen-free. Anneal ambients that can have low oxygen content or are oxygen free are hydrogen plasma anneal, hydrogen anneal, vacuum anneal, argon anneal, and nitrogen anneal. The diamond material layer ADM deposition temperature preferably at room temperature but can be at a cryogenic temperature or above room temperature. For the case of diamond deposition on ZnS, the deposition temperature may be less than 450°C . or less than 100°C . Zinc sulfide can sublime at anneal temperatures greater than 550°C . A cap material layer deposited on the surface of the zinc sulfide substrate can help prevent it from decomposing at a temperature greater than 550°C . The interface material layer can act as the cap material layer.

For applications of the diamond layer or diamond composite layer that are used for protective coating on a substrate for infrared window application, it may be desirable that the diamond material and the other materials with the diamond composite layer have good infrared transmission properties at the wavelength of interest. For mid wavelength application, the wavelength of interest is approximately 3 to 5 micron wavelength while for long wavelength application, the wavelength of interest is approximately 8 to 12 micron wavelengths. The diamond powder can be selected to have good

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optical transparency at the wavelengths of interest. One form of diamond powders that have improved optical transparency is diamond powders formed by crushing synthetic or IIA diamond powders. IIA diamond powders have low nitrogen content and will have improved optical transparency compared to other diamond powders. The IIA diamond material can be natural diamond material or synthetic diamond material that is crushed to form powders. The IIA diamond material can be grown by chemical vapor deposition techniques. These diamond powders are often known as crushed diamond powder. They generally have the property of being single crystal diamond. Other forms of diamond powders can be used but the other forms of diamond powders may have reduced optical transparency compared to the crushed diamond powders.

The ADM deposition technique utilizes an impact solidification mechanism of fine (0.1-1 μm) particles to form a high-density or low porosity nanocrystalline layer. ADM is often performed at room temperature at normal (perpendicular) deposition angle to the substrate surface. FIG. 6 schematically illustrates the ADM apparatus. A source of gas such as a tank of gas or other source of gas is connected to a first chamber (or aerosol chamber) with a gas flow control means used to control the flow of gas between the source of gas and the first chamber. In this process, a powder (or particles) of selected size or size distribution is aerosolized and preferably deagglomerated either within the first chamber or external to the first chamber. The ambient within the first chamber generally comprises flowing nitrogen, helium, argon, or oxygen or a combination of gases, with the gas or gas combination within the first chamber being at a first selected pressure or a selected variable pressure schedule. The first chamber is connected with at least an air flow connection between the first chamber and with a second chamber (or deposition chamber) with the second chamber having an ambient or vacuum with a selected pressure that is lower than the selected pressure within the first chamber. The air flow connection between the first chamber and the second chamber can contain a nozzle of selected dimension that confines the air flow between the first chamber and the second chamber to a smaller dimension than the dimension of the air flow connection. Because of the pressure of gas in the first chamber is at a higher pressure than the pressure of gas in the second chamber, the first chamber injects gas into a second chamber. The second chamber contains a target substrate. The second chamber is connected to a pump and is generally pumped to less than 1 Torr vacuum by the pump. The pressure differential accelerates the aerosolized particles through a nozzle toward the substrate, normal to the surface of the substrate or at an angle relative to the substrate. The ADM can form thick (>100 μm), dense (95% bulk density) films of ceramic or metallic compounds onto a variety of substrates.

FIG. 11 illustrates the accepted deposition mechanism. The film initially forms when incident particles fracture and embed into the substrate. This well-adhered anchoring layer is comprised of 10-50 nm sized particles. Subsequent impact of particles compact the film and bond the crystallites through close-range mechanical and chemical forces. Since only fracturing occurs, the fabricated film has the same crystalline structure and inherent properties as the raw powder.

An interface material layer can act as a material layer that facilitates the large difference in thermal expansion coefficient between the diamond material layer and the substrate material. The interface material layer can also act as material layer that can be impacted by the high velocity particles without damaging or eroding the substrate material. The interface material layer can comprise diamond, germanium

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carbide, YbF₃, YF₃, BaF₂, CaF₂, CeF₃, ZnSe, ZnS, Ge, HfO₂, Y₂O₃, ZrO₂, CdTe, gallium sulfide, polymer, Al₂O₃, magnesium fluoride, AlN, a combination thereof, or sequentially stacked layers thereof. The interface material layer may also be a polymer, adhesive, amorphous material, polycrystalline material, highly oriented material, infrared transparent material, semiconductor, dielectric, soft material layer, material layer that has the property of yielding when stressed or strained, or a low modulus material. Examples of interface materials are amorphous germanium, polycrystalline germanium, highly ordered germanium, polymer, and other materials known to those skilled in the art. The interface material layer can be selected to have a selected hardness, a selected modulus, a selected fracture strength, a selected density, a selected porosity, a selected adhesion strength of the diamond or diamond composite material to the substrate, a selected thermal expansion coefficient, and/or other properties known to those skilled in the art that would prevent damage or erosion of the substrate material or provide the desired thermal expansion coefficient material. The interface material layer can be deposited by ADM, chemical vapor deposition method, atomic layer deposition method, metal organic deposition method, sol-gel method, electrochemical method, spray pyrolysis method, or other methods known to those skilled in the art.

A diamond composite material that is formed by ADM can comprise a diamond-germanium composite material, a diamond-ZnS, a diamond-ZnSe material, diamond-dielectric material, or diamond-semiconductor material known to those skilled in the art. An approach for forming diamond composite material using ADM is to mix diamond powders and germanium powders and an ultrasonic agitator or other way to get a good mixture of diamond and germanium particles. The mixture of diamond and germanium particles is next loaded into the aerosol generation portion of the ADM tool. The mixture of diamond and germanium particles are made to go into the ambient and then the differential pressure directs the mixture of diamond and germanium particles to a substrate.

The diamond powders and germanium powders may be also mixed in an ultrasonic agitator or other apparatus to get a good mixture of diamond and germanium particles. The mixture of diamond and germanium particles is next loaded into the aerosol generation portion of the ADM tool. The mixture of diamond and germanium particles are made to go into the ambient and then the differential pressure directs the mixture of diamond and germanium particles to a substrate.

A graded diamond composite material or stepped diamond composite material or laminated composite material layer that is formed by ADM can comprise a diamond-germanium composite material, a diamond-ZnS, a diamond-ZnSe material, diamond-dielectric material, or diamond-semiconductor material with a variation in the percentage of diamond in the composite material layer as a function of depth. An approach for forming diamond composite material using ADM is to have two nozzles with one nozzle directing diamond particles to the substrate and a second nozzle directing germanium or ZnSe particles toward the substrate. The nozzles can alternately deposit a diamond material and then deposit a germanium layer (or ZnSe layer) to form a laminated material layer.

The spacer material layer can be selected to help accommodate difference in the thermal expansion coefficient between diamond and the substrate material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window) without diamond material or spacer material delamination from the substrate, or without the diamond material layer, the spacer material layer, or the material cracking due to stress or strain in the

material. For infrared window applications, a spacer material layer may comprise germanium, ZnSe, or other material that is transparent in the infrared wavelengths. For mechanical applications, the spacer material layer can be a metal, semiconductor, insulator, dielectric, amorphous, or polycrystalline. The spacer material layer can be deposited, by example, by ADM, sputtering, physical vapor deposition, CVD, PECVD, MOCVD, ALD, ALE, or other method known to those skilled in the art.

An optional CVD diamond layer may be deposited on the surface of the ADM deposited diamond material layer, the diamond composite material layer, graded diamond material layer, or stepped diamond composite material layer. The advantage of this structure is that the ADM deposited diamond material layer, diamond composite material layer, graded diamond material layer, or stepped diamond composite material layer will have a lower value of thermal coefficient of expansion mismatch to ZnS compared the value of the thermal coefficient of thermal expansion mismatch of CVD diamond layer to ZnS. This lower value of thermal coefficient of expansion mismatch will allow a larger temperature increase without the CVD diamond form delaminating from the surface. The CVD diamond layer can provide a high degree of protection from impacts of rain drops or dust particles.

The CVD diamond layer can be a CVD diamond nanocrystalline layer. It can be desirable that the surface of the diamond layer, diamond composite layer, CVD diamond layer or CVD nanocrystalline diamond layer have low surface roughness, especially to reduce light scattering. The advantage of a CVD diamond nanocrystalline layer is that the grain size in the CVD diamond nanocrystalline layer is typically much smaller than the diamond grain size in a CVD diamond layer and thus, the surface roughness on the surface of the CVD diamond nanocrystalline layer is less than the surface roughness on the surface of a CVD diamond layer. An option is that the diamond layer, diamond composite layer, CVD diamond layer, or the CVD nanocrystalline diamond layer can be polished to reduce the surface roughness. The polishing can be mechanical or a combination of mechanical and chemical polishing. An additional option for reducing the surface roughness of the diamond layer, diamond composite layer, CVD diamond layer, or CVD nanocrystalline diamond layer is to use a diamond turning tool to reduce the surface roughness. Another option for achieving low surface roughness on the surface of the diamond layer, diamond composite layer, CVD diamond layer, or CVD nanocrystalline diamond layer is to have the aerosol deposition particles incident on the surface of the diamond composite layer at an angle different than an angle that is normal to the surface.

Another aspect is an AlN coating made by sputtering, physical vapor deposition, atomic layer deposition, atomic layer epitaxy, MBE, or MOCVD on the diamond surface to provide oxidation resistance layer for the diamond material or diamond-composite material to act as an antireflecting coating on the diamond material.

An optional sealing layer can be deposited on the substrate material to protect the substrate from the ambient during the growth of the interface material layer. A candidate interface material layer is CVD diamond. The ambient for depositing CVD diamond typically has atomic hydrogen which is known to rapidly etch ZnS. A pinhole free sealing layer can protect the ZnS from the atomic hydrogen present in a CVD diamond ambient. It is desirable that the sealing layer be pinhole free. It is also desirable that the sealing layer be transparent for the wavelengths of interest for the application. Atomic layer deposition is attractive for the sealing layer because atomic

layer deposition layers can be pinhole free, are also grown at temperatures below about 400° C., and can be ultrathin material layer thickness. Candidate sealing layers include one or more of the following, but are not limited to, are hafnium oxide (HfO₂), yttrium oxide (Y₂O₃), zirconium oxide (ZrO₂), aluminum nitride (AlN), and gallium arsenide (GaAs). The sealing layer can have a thickness from about 0.3 nm to about 2 micron, with selected thicknesses in the range of 1 nm to 20 nm being a preferred selected thickness. The optional sealing layer can function as an antireflecting coating by optimally selecting the index of refraction and thickness as is known by those skilled in the art. The optional sealing layer can be combined with an optional nucleation layer, the optional interface material layer, diamond material layer, or the diamond composite material layer to form an antireflection structure.

An optional nucleation layer can be deposited on the substrate that can support the growth of the interface material layer. For the case that the interface material layer is a CVD diamond layer, the nucleation layer can be ultrasonic deposited nanocrystalline diamond layer.

In one embodiment a diamond material layer is deposited directly on a substrate. For this embodiment, the aerosol deposited diamond material layer is formed directly on a substrate material. The substrate material can be a structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window material. The diamond material layer can be a hard, high thermal conductivity coating for the case of the diamond used as a protective coating on a ZnS or ZnSe infrared window or infrared dome material. The diamond powder that is loaded into the aerosol generation portion of the aerosol deposition method system can be selected to facilitate the fracture of diamond powders when the diamond powder impacts a material. For example, the diamond powder can be selected to have irregular shape rather than an approximately spherical shape to facilitate the fracture of the diamond powder when the powder impacts the material. The diamond powder can be selected to have a dimension of approximately 500 nm or larger. One of the reasons for selecting a powder of approximately 500 nm or larger is that there will be less of a tendency for the diamond powder to stick to each other in the aerosol generation portion of the ADM system. The aerosol deposit method is similar to that described by Akedo, "Room Temperature Impact Consolidation (RTIC) of Fine Ceramic Powder by Aerosol Deposition Method and Applications to Microdevices" J. Thermal Spray Technol., 17(2), 181-198 (2008), except that a diamond powder is used for the ADM and the diamond powder can be selected to have enhanced fracturing by selecting a diamond powder with an irregular shape. The substrate material will typically be at room temperature during the deposition of the diamond material layer. The diamond material layer thickness will depend on the application and may be in the range of 0.5 micron to 200 microns thick.

In another embodiment a diamond material layer is deposited on interface material on a substrate. For this embodiment, an interface material layer is first deposited on a substrate material. The substrate material can be a structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window material. The interface material layer can act as material layer that can be impacted by the high velocity particles without damaging or eroding the substrate material. The interface material layer can be a polymer, adhesive, amorphous material, polycrystalline material, highly oriented material, infrared transparent material, semiconductor, dielectric, soft material layer, material layer that has the property of yielding when stressed or

strained, or a low modulus material. Examples of candidate interface material are amorphous germanium, polycrystalline germanium, highly ordered germanium, polymer, and other material known to those skilled in the art. The interface material layer can be annealed at a selected temperature to improve its properties prior to the deposition of the diamond material layer. An anneal at 600° C. or greater will typically grow the size of the nanocrystals in the nanoceramic material and also reduce the porosity of the interface material layer. The diamond material layer can be a hard, high thermal conductivity coating on a material for the case of the diamond used as a protective coating on a ZnS or ZnSe infrared window or infrared dome material. The diamond powder that is loaded into the aerosol generation portion of the aerosol deposition method system can be selected to facilitate the fracture of diamond powders when the diamond powder impacts a material. For example, the diamond powder can be selected to have irregular shape rather than an approximately spherical shape to facilitate the fracture of the diamond powder when the powder impacts the material. The diamond powder can be selected to have a dimension of approximately 500 nm or larger. One of the reasons for selecting a powder of approximately 500 nm or larger is that there will be less of a tendency for the diamond powder to stick to each other in the aerosol generation portion of the ADM system. The aerosol deposit method is similar to that described by Akedo, "Room Temperature Impact Consolidation (RTIC) of Fine Ceramic Powder by Aerosol Deposition Method and Applications to Microdevices" J. Thermal Spray Technol., 17(2), 181-198 (2008), except that a diamond powder will be used for the ADM and the diamond powder can be selected to have enhanced fracturing by selecting a diamond powder with an irregular shape. The material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window) will typically be at room temperature during the deposition of the diamond material layer on a material by the ADM. The diamond material layer thickness will depend on the application be can be in the range of 0.5 micron to 200 microns thick.

In another embodiment a diamond composite material layer is deposited on a substrate. For this embodiment, multiple powder types are present in the aerosol generation portion of the ADM system. The diamond powders can be combined one or more non-diamond powders. The non-diamond powders for long infrared wavelength protective coating on a infrared window can comprise germanium carbide, YbF₃, YF₃, BaF₂, CaF₂, CeF₃, ZrSe, ZnS, Ge, HfO₂, Y₂O₃, ZrO₂, CdTe, gallium sulfide, germanium gallium sulfide, or polymer. The non-diamond powder can consist of core shell powder having a diamond core and a non-diamond material shell. Several candidate materials for the shell material are YbF₃, YF₃, BaF₂, CeF₃, ZrSe, ZnS, Ge, HfO₂, Y₂O₃, gallium sulfide, germanium gallium sulfide, gallium, polymer, silica, Al₂O₃, or other material layers. The shell material layer growth approach can be selected from approaches of electrochemical wet chemical approach, hydrothermal wet chemical coating approach, and fluidized atomic layer deposition, fluidized molecular layer deposition, atomic layer electrochemical deposition approach and other approaches known to those skilled in the art.

The powders can be premixed or can be mixed within the generation portion of the ADM system. The diamond-composite material that is formed by ADM can comprise a diamond-germanium composite material, a diamond-ZnS, a diamond-ZnSe material, diamond-dielectric material, or diamond-semiconductor material known to those skilled in the art. An approach for forming diamond composite material

using ADM is to mix diamond powders and germanium powders and an ultrasonic agitator or other way to get a good mixture of diamond and germanium particles. The mixture of diamond and germanium particles is next loaded into the aerosol generation portion of the ADM tool. The mixture of diamond and germanium particles are made to go into the ambient and then the differential pressure directs the mixture of diamond and germanium particles to a substrate. The aerosol deposited diamond composite material layer would be formed directly on a substrate material. The material can be a structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window material. The diamond material layer can be a hard, high thermal conductivity coating for the case of the diamond used as a protective coating on a ZnS or ZnSe infrared window or infrared dome material. The diamond powder that is loaded into the aerosol generation portion of the aerosol deposition method system can be selected to facilitate the fracture of diamond powders when the diamond powder impacts a material. For example, the diamond powder can be selected to have irregular shape rather than an approximately spherical shape to facilitate the fracture of the diamond powder when the powder impacts the material. The diamond powder can be selected to have a dimension of approximately 500 nm or larger. One of the reasons for selecting a powder of approximately 500 nm or larger is that there will be less of a tendency for the diamond powder to stick to each other in the aerosol generation portion of the ADM system. The aerosol deposit method is similar to that described by Akedo, "Room Temperature Impact Consolidation (RTIC) of Fine Ceramic Powder by Aerosol Deposition Method and Applications to Microdevices" J. Thermal Spray Technol., 17(2), 181-198 (2008), except that a diamond powder is used for the ADM and the diamond powder can be selected to have enhanced fracturing by selecting a diamond powder with an irregular shape. The material (structural material, mechanical material, substrate, semiconductor, insulator, infrared dome, or infrared window) will typically be at room temperature during the deposition of the diamond material layer on a material by the ADM. The diamond material layer thickness will depend on the application be can be in the range of 0.5 micron to 200 microns thick.

The following example is given to illustrate specific applications. These specific examples are not intended to limit the scope of the disclosure in this application.

Example

ZnS/Diamond (Z/D) Composite Layers

Initial depositions of Z/D composites were made on sapphire, Si, and ZnS substrates. An advantage of using the Z/D material as compared to diamond alone is that it is transparent in both the mid- and long-wavelength infrared. A second advantage is that the Z/D coating has a closer thermal expansion match to the ZnS (6.3×10^{-6} C.⁻¹) window than a diamond (1×10^{-6} C.⁻¹) coating alone and thus allows a wider temperature excursion without delaminating or cracking.

FIG. 7 is a representative scanning electron microscopy (SEM) image of the edge of a 60% wt. ZnS Z/D film on sapphire. The film was well compacted and continuous. Fragments of diamond and ZnS could be found on the film surface and particles within the film were fractured and well adhered. FIG. 8 shows results of deposition onto sapphire which, for a pressure differential of 200 Torr, have a linear trend from sputter erosion of the substrate to formation of a film with increasing fractions of ZnS. The crossover from abrasion to

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film formation occurs between 50-60% ZnS and a mixture of 90% ZnS and 10% diamond forms a well-adhered film of about 0.7 microns thickness at a rate of 0.14 microns/min. A similar trend occurs for deposition onto Si, but initial efforts resulted in abrasion of ZnS substrates with only a sparsely embedded diamond anchor layer possibly due to the lack of plasticity at the micrometer scale that can be seen in SEM images on both sapphire and Si.

Averaged infrared transmission measurements across regions on the film are shown in FIG. 9. The sharp drop at about 7 μm is the characteristic absorption of sapphire. All mixtures measured had a transparency above 80% in the range of 3-7 μm . FIG. 10 shows the relation between abrasion, percent mixture, and transmittance of the films at 5 μm which is located within a minor diamond absorption band. Above 50% ZnS the transmittance is decreasing with increasing film thickness. Since the thickness is not sufficient to account for increased absorption the trend is likely due to an increase in diamond content in the film, i.e., even though there is less diamond by percent there is more of it in the film. The cross-over from abrasion to film formation may be due to local plasticity, grain dislocations, defects, electrostatic, and/or chemical properties of the constituent materials.

Obviously, many modifications and variations are possible in light of the above teachings. It is therefore to be understood that the claimed subject matter may be practiced otherwise than as specifically described. Any reference to claim elements in the singular, e.g., using the articles "a," "an," "the," or "said" is not construed as limiting the element to the singular.

What is claimed is:

1. A structure comprising:
 - a substrate;
 - a diamond layer on the substrate comprising diamond nanoparticles;
 - wherein the diamond nanoparticles are formed by colliding diamond particles with the substrate; and
 - a sealing layer between the diamond layer and the substrate.
2. The structure of claim 1, wherein the substrate comprises ZnS, ZnSe, a semiconductor, an insulator, a metal, a single crystal material, a non-single crystal material, or an infrared window.
3. The structure of claim 1, wherein the diamond nanoparticles are 10-200 nm in size.
4. The structure of claim 1, wherein the diamond nanoparticles are bonded together by mechanochemical reactions.
5. The structure of claim 1, wherein the diamond layer comprises at least 1 wt. % diamond.
6. The structure of claim 1, wherein the diamond layer comprises at least 10 wt. % diamond.
7. The structure of claim 1, wherein the diamond layer is a diamond composite layer.
8. The structure of claim 7, wherein the diamond composite layer comprises germanium, ZnS, ZnSe, a dielectric, a semiconductor, YbF₃, YF₃, BaF₂, CeF₃, HfO₂, Y₂O₃, GaS, germanium gallium sulfide, gallium, a polymer, or silica.
9. The structure of claim 7, wherein the percentage of diamond in the diamond composite layer varies with the depth within the diamond composite layer.
10. The structure of claim 1, wherein the structure comprises:
 - a plurality of the diamond layers; and
 - a spacer layer between each adjacent pair of the diamond layers.
11. The structure of claim 10, wherein the spacer layers comprise germanium, ZnSe, an infrared transparent material,

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a metal, a semiconductor, an insulator, a dielectric, an amorphous material, or a polycrystalline material.

12. The structure of claim 1, wherein the structure further comprises a nucleation layer between the diamond layer and the substrate.

13. The structure of claim 1, wherein the structure further comprises a CVD diamond layer on the diamond layer.

14. The structure of claim 1, wherein the structure further comprises:

- an interface layer between the diamond layer and the substrate.

15. The structure of claim 14, wherein the interface layer has a thickness that prevents penetration of the diamond nanoparticles into the substrate.

16. The structure of claim 14, wherein the interface layer has a thickness that allows penetration of the diamond nanoparticles into the substrate.

17. The structure of claim 14, wherein the interface layer comprises a polymer, an adhesive, an amorphous material, a polycrystalline material, a highly oriented material, an optically transparent material, an infrared transparent material, a semiconductor, a dielectric, a CVD diamond layer, germanium carbide, YbF₃, YF₃, BaF₂, CeF₃, ZrSe, ZnS, Ge, HfO₂, Y₂O₃, ZrO₂, CdTe, GaS, Al₂O₃, magnesium fluoride, AlN, a combination thereof, or sequentially stacked layers thereof.

18. The structure of claim 1, wherein the structure further comprises:

- an anti-oxidation or anti-reflective layer on the diamond layer.

19. The structure of claim 18, wherein the anti-oxidation or anti-reflective layer comprises AlN.

20. A method comprising:

- depositing a nucleation layer on a substrate;

- directing an aerosol comprising submicron diamond particles toward the substrate; and

- forming on the nucleation layer a diamond layer comprising diamond nanoparticles formed by the diamond particles colliding with the substrate.

21. The method of claim 20, wherein the diamond layer is formed at less than 450° C.

22. The method of claim 20, wherein the diamond layer is formed at room temperature.

23. The method of claim 20, wherein the aerosol is directed at an angle other than normal to the substrate.

24. The method of claim 20, wherein the diamond particles comprise IIA diamond particles or crushed diamond particles.

25. The method of claim 20, wherein the diamond particles are directed toward the substrate at about 250 m/s.

26. The method of claim 20, wherein the aerosol further comprises one or more non-diamond powders.

27. The method of claim 20, wherein the diamond particles comprise a diamond core and a non-diamond shell surrounding the core.

28. The method of claim 27, wherein the non-diamond shell comprises YbF₃, YF₃, BaF₂, CeF₃, ZrSe, ZnS, Ge, HfO₂, Y₂O₃, GaS, germanium gallium sulfide, gallium, a polymer, silica, or Al₂O₃.

29. The method of claim 26, wherein the percent of diamond particles in the aerosol is varied with the depth of the diamond composite layer.

30. The method of claim 20, further comprising:

- depositing a spacer layer on the diamond layer;

- optionally repeating forming the diamond layer and depositing the spacer layer one or more times; and

- depositing a final diamond layer.

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31. The method of claim **20**, further comprising:
depositing a sealing layer on the substrate before forming
the diamond layer.

32. The method of claim **20**, further comprising:
depositing an interface layer on the substrate before form- 5
ing the diamond layer.

33. The method of claim **20**, further comprising:
depositing an anti-oxidation or anti-reflective layer on the
diamond layer.

34. The method of claim **20**, further comprising: 10
annealing the diamond layer.

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